

I CLAIM

Claim 1. A press, punch and die combination which comprises a punch with its axis at an acute angle to the surface of a die where a portion of the sheet metal rests while the other portion is formed 5 with an over hanging shape.

Claim 2. The press, punch and die described in Claim 1, wherein it can be connected to an indexing mechanism to drive a sheet metal circular disc with 4 to 200 separate extending beams on the outer diameter to be bent separately.

10 Claim 3. The press, punch and die described in Claim 1, wherein a groove can be formed in the bent portion.